

Work Order ID 59993

June 22, 2010 12:44:31 PM



Page 1

Item ID: D350-636-013

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

0.00

100



DC

DOCUMENT CONTROL

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-013 CHG 005

*HJ for BG 10/07/29*

*Siolex*

*B59993*

# Work Order ID 59993

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Item ID: D350-636-013

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Setup

Start



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Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
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Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110



Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 6 (D2750-3 details).Drill using drill Jig DT8150 & DT8864 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.Deburr.

4- Drill fwd step holes using DT9616. Ensure proper positioning.

5-Drill pilot holes for the blade fitting bolt holes using DT8983. Open to 0.500".

6- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting.

7-Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

8-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297"

9-Open up holes of Detail S to 0.297" (total of 2 holes per side)

10-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004  
A/R: Aluminum Rod

~~851922~~  
M114242

BE 10/07/01

10-6-25

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Item ID: D350-636-013

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Item Name: Skidtube LH

Start Date: 6/22/10 Start Qty: 1.00

Required Date: 6/25/10 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-Grind welds flush as per Dwg D2750

12- scribe batch #.

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

3 BE 10/07/05

8 10/07/05

8 10/07/05

(10)

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

1 MP/7/6

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

1 BE10/07/06

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Item ID: D350-636-013

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Start Date: 6/22/10 Start Qty: 1.00

Required Date: 6/25/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Skidtubes

Skidtubes

0.00

0.00

**Memo**

1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750

2- Open holes section AV-AV 0.3125" (4 per side)

3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R ☐ ☐ ☐ Sikaflex-291batch: M113519 ☐ ☐ ☐

exp. date: 07/16 10/11/30

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 10)

A/R ☐ ☐ ☐ Aluminum Rod

batch: M114242

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

M61716

3 BE 10/07/07

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

8/10/07/08

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

8/10/07/08

(X)

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

=> 9/10/07/16

X1

g

Hand Finishing

L Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME: 8:30  
OVEN TEMPERATURE: 300°  
FINISH TIME: 9:00

0.00

210

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

Inspect for foreign object per QSI 024

0.00

220

HandFinishing

0.00



HandFinish

Hand Finishing

Memo

1-Install inserts as per dwg D2750

0.00

=> M 10/07/22

=> M 10/07/22

1 BL 10-7-19.

1 /

1 /

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Item ID: D350-636-013

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Setup Start



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Stop



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Required Date: 6/25/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230



HandFinish

HandFinishing

0.00

=> JH 10/07/27

0.00

Memo

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750  
SIKA FLEX 241  
BATCH: M115114  
EXP DATE: 11/10/11

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube  
A/R 55-o-ring lube batch: M1114189

5-Coat all exposed fasteners with "LPS Procyon" batch: M1104251

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 wheels

0.00

Memo

(70)



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Item ID: D350-636-013

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Setup Start



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Item Name: Skidtube LH

Stop



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Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
Number Insp.  
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*6/22/29 @*

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*5/10/29**(10)*

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-013

*Rev H*  
*Loc 72**10/7/30* *SP*

**Work Order ID 59993**

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Item ID: D350-636-013

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube LH

Start Date: 6/22/10 Start Qty: 1.00

Required Date: 6/25/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/03

M 10-7-30

# Picklist Print

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10

Work Order ID: 59993



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 6/22/10

Required Date: 6/25/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ  
 IPP rev I 06.03.30 Per rev. D dwg EC  
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225  Insert		Purchased	No			230	Each	6,491.000	38	38			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				PK011			6491						
					110768		6491						
AN3C5A  Bolt		Purchased	No			230	Each	242.0000	34	34			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST350			227						
					114330		11						
					114523		18						
					114808		198						
				ST351			15						
					113121		10						
					114108		5						
AN3C6A  BOLT		Purchased	No			230	Each	501.0000	4	4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST351			501						
					111982		501						

x38 JH 10/07/22

1115015 x34 JH 10/07/22

x4 JH 10/07/22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	1A							

**NOTE:** Date & initial all entries

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Work Order ID: 59993

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 6/22/10

Required Date: 6/25/10

Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No 230 Each 167.0000 4 4



BOLT

Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST344	165	
111649	2	
114653	38	
114784	50	
114941	75	

AN8C21A Purchased No 260 Each 81.0000 2 2



BOLT

Location	Loc Qty	Loc Code
ST345	81	
113558	41	
114653	40	

AN8C35A Purchased No 230 Each 39.0000 1 1



BOLT

Location	Loc Qty	Loc Code
FP	1	
110847	1	
ST346	38	
114442	38	

AN960C10L NAS1149C0332 Purchased No 230 Each 0.0000 38 38



washer

M115000



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Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 59993

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 6/22/10

Required Date: 6/25/10

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased

No

230

Each

61.0000

1

1



WASHER

## Location

## Loc Qty

## Loc Code

ST348

61

58

3

110584  
111424

AN960C816L

Purchased

No

260

Each

61.0000

2



WASHER

## Location

## Loc Qty

## Loc Code

ST348

61

58

3

110584  
111424

D2600-3-BENT

Manufactured

No

110

Each

0.0000



Extrusion Bent

D2739

Manufactured

No

160

Each

2.0000



350 I Beam

## Location

## Loc Qty

## Loc Code

LG

2

2

59406

D2741

Manufactured

No

260

Each

32.0000



Blade, 350 Skidtube

## Location

## Loc Qty

## Loc Code

ST466

32

12

20

55905

57949

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Page 3

x1 1010762

610762

1110584

D B59410 101716

B60225 101716

610762

55905

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-636-013

Parent Item Name: Skidtube LH



Start Date: 6/22/10

Required Date: 6/25/10

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 220 Each

331.0000 8 8



Crossbolt Spacer

Location	Loc Qty
LG	331
50281	10
57953	2
59111	319

Loc Code

D2744 Manufactured No 160 Each

42.0000 1 1



Cap

Location	Loc Qty
LG	42
51922	6
59198	36

Loc Code

D2745 Manufactured No 230 Each

246.0000 8 8



Bushing

Location	Loc Qty
ST023	246
52311	5
57914	21
59112	220

Loc Code

D3488-041 Manufactured No 230 Each

22.0000 1 1



Blade Fitting Assembly, LH

Location	Loc Qty
FP	14
53915	14
FP007	8
56052	8

Loc Code

B BE 10/07/07

BE 10/07/01

X B 10/07/02

XI 10/07/22

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Parent Item: D350-636-013

Parent Item Name: Skidtube LH



D3490-1 Manufactured No 160 Each



Cross Bolt Spacer

Location	Loc Qty
LG	35
59424	35

D3490-5 Manufactured No 160 Each



Cross Bolt Spacer

Location	Loc Qty
LG	82
46490	22
59230	60

D3492-041 Manufactured No 230 Each



Plug Assembly

Location	Loc Qty
FP013	169
58180	4
59174	80
59189	4
59420	81

D3492-1 Manufactured No 230 Each



Plug

Location	Loc Qty
FP	18
48274	18

D3492-5 Manufactured No 230 Each



Plug

X D3492-045 / 51638

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Start Date: 6/22/10

Start Qty: 1.00

Required Date: 6/25/10

Required Qty: 1.00

35.0000 4 4



Loc Code

82.0000 4 4



Loc Code

169.0000 8 8



Loc Code

18.0000 8 8



Loc Code

0.0000 8 8



4 BE 10/07/07

4 BE 10/07/07

x 8 10/07/22

x 8 10/07/22

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W/O:		WORK ORDER CHANGES						
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Work Order ID: 59993

Parent Item: D350-636-013

Parent Item Name: Skidtube LH



Start Date: 6/22/10

Required Date: 6/25/10

Start Qty: 1.00

Required Qty: 1.00

5 D3493-1 Manufactured No 110 Each 45.0000 2 2  
Washer

Location	Loc Qty
ST065	45
57825	3
59127	42

Loc Code

D3535-25 Manufactured No 230 Each 9.0000 1 1  
Wearshoe

Location	Loc Qty
FP18	9
59150	9

Loc Code

D3536-25 Manufactured No 230 Each 15.0000 1 1  
Gasket

Location	Loc Qty
FP12	15
58820	15

Loc Code

D3537-1 Manufactured No 230 Each 50.0000 3 3  
Wearpad

Location	Loc Qty
FP	1
55465	1
FP17	25
57713	3
59116	22
FP18	24
59710	24

Loc Code

*Copy*

59120

x1 10/07/22

x1 10/07/22

B59593 x3 10/07/22

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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 22, 2010 12:44:03 PM

Page 7

Work Order ID: 59993

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

D3631-1



Washer

Manufactured No

230 Each

Start Date: 6/22/10

Start Qty: 1.00

Required Date: 6/25/10

Required Qty: 1.00

351.0000 8 8



## Location

## Loc Qty

## Loc Code

ST076

351

52693

206

54388

145

B60755

x3 ul 10/07/28  
x5 ul 10/07/22

D3672-1



Phenolic Washer

Manufactured No

260 Each

1,159.000 4 4



## Location

## Loc Qty

## Loc Code

ST077

1159

51674

159

52505

1000

x4 ul 10/07/22

D3672-13



Phenolic Washer

Purchased No

260 Each

864.0000 2 2



10/7/29

## Location

## Loc Qty

## Loc Code

ST077

864

54363

864

54363

D3791-1



Wearplate

Manufactured No

230 Each

18.0000 1 1



## Location

## Loc Qty

## Loc Code

FP17

18

58573

11

58906

7

B59 626

x1 ul 10/07/22

June 22, 2010 12:44:03 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

June 22, 2010 12:44:03 PM

Page 8

Work Order ID: 59993

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 6/22/10

Required Date: 6/25/10

Start Qty: 1.00

Required Qty: 1.00

D3793-1 Manufactured No 230 Each 12.0000 1 1  
Wearshoe

Location

Loc Qty

Loc Code

FP18 12  
59151 12  
230 Each 12.0000 1 1

D3793-3 Manufactured No 230 Each 12.0000 1 1  
Wearshoe

Location

Loc Qty

Loc Code

FP18 11  
59152 11  
FP19 1  
57947 1  
230 Each 29.0000 1 1

D3794-1 Manufactured No 230 Each 29.0000 1 1  
Gasket

Location

Loc Qty

Loc Code

FP010 29  
57942 18  
59627 11  
230 Each 23.0000 1 1

D3794-3 Manufactured No 230 Each 23.0000 1 1  
Gasket

Location

Loc Qty

Loc Code

FP18 23  
56066 11  
59153 12

X 1 Jul 10/07/22

X 1 Jul 10/07/22

X 1 Jul 10/07/22

X 1 Jul 10/07/22

June 22, 2010 12:44:03 PM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 22, 2010 12:44:24 PM

Page 9

Work Order ID: 59993

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 6/22/10

Required Date: 6/25/10

Start Qty: 1.00

Required Qty: 1.00

MS21043-6 Purchased No 230 Each 766.0000 4 4



NUT

Location Loc Qty Loc Code

ST301 766

12314 766

MS21083C8 Purchased No 230 Each 96.0000 1 1



NUT

Location Loc Qty Loc Code

ST303 96

113845 7

114934 89

MS21083C8 Purchased No 260 Each 96.0000 1 2



NUT

Location Loc Qty Loc Code

ST303 96

113845 7

114934 89

NAS1611-005 Purchased No 230 Each 290.0000 8 8



O-RING

Location Loc Qty Loc Code

FP002 290

106099 190

114220 100

24 21 10/07/22

21 21 10/07/22

114934

28 24 10/07/22

6/1/29

June 22, 2010 12:44:24 PM

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 22, 2010 12:44:25 PM

Page 10

Work Order ID: 59993



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 6/22/10

Required Date: 6/25/10

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

275.0000

8

8



O-RING

PTO =>



PTO =>

## Location

## Loc Qty

## Loc Code

FP

275

110715

100

110915

175

June 22, 2010 12:44:25 PM

Shop Packet Print

Page 10

W/O: 59993		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/07/22	230	Replac NAS 1611-010 "O" Rings with D2594-3/B59358	HL	10/07/22	8		6

Part No: D350-636-013 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083CB	NUT
4	4	4	4	NAS1515H3L	WASHER

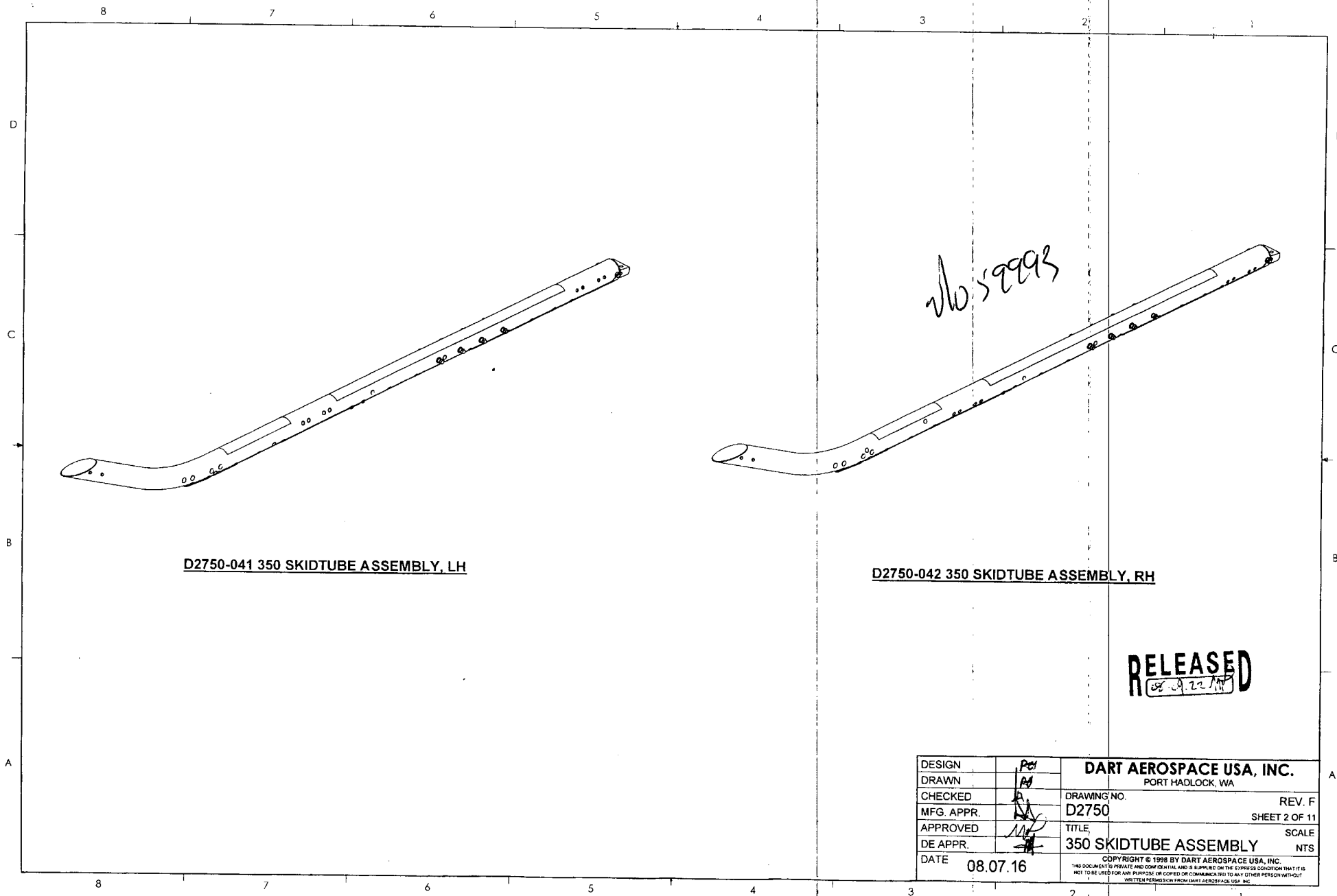
# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

w/o 59993

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083CB	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	AK	D2750	SHEET 1 OF 11
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



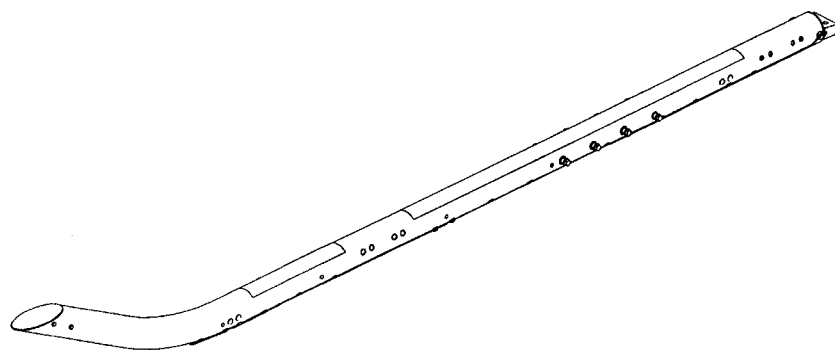
D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

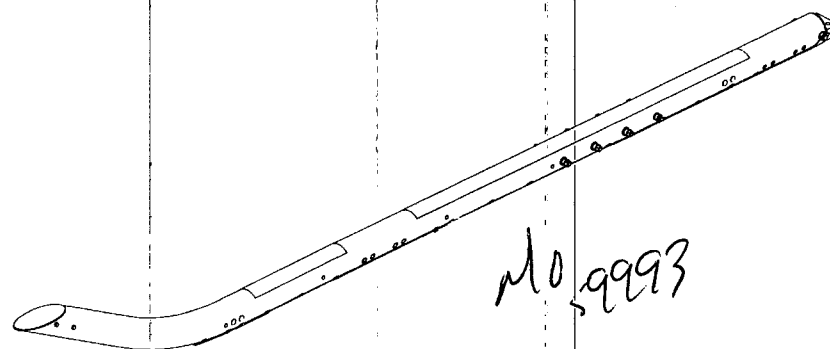
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 89.12.17

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DRAWN	AM	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	ME	D2750	SHEET 2 OF 11
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	350 SKIDTUBE ASSEMBLY	NTS
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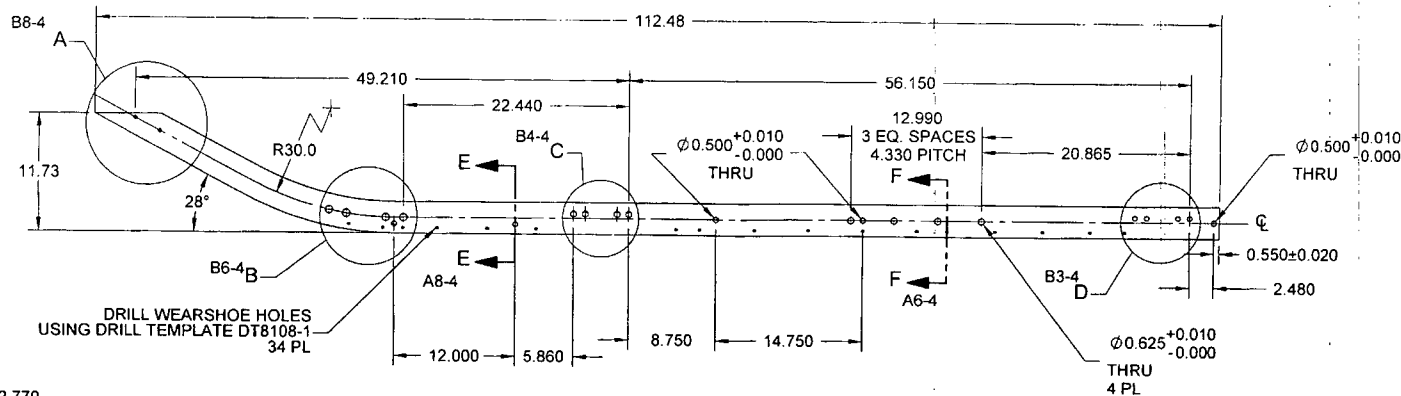
D2750-043 350 SKIDTUBE ASSEMBLY, LH



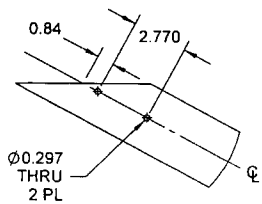
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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(68-9-22/111)

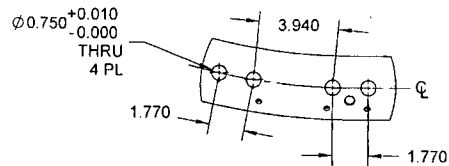
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DRAWN	PD	
CHECKED	NA	DRAWING NO. REV. F
MFG. APPR.	NA	D2750 SHEET 3 OF 11
APPROVED	NA	TITLE SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>



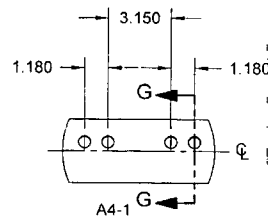
**D2750-1 LH SKIDTUBE**



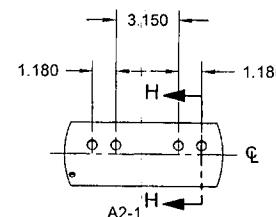
**DETAIL A**  
SCALE 2X



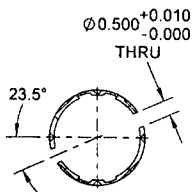
**DETAIL B**  
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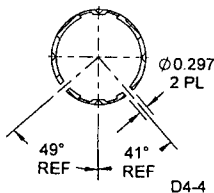
**DETAIL C**  
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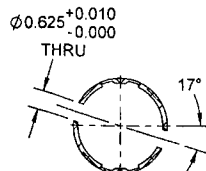
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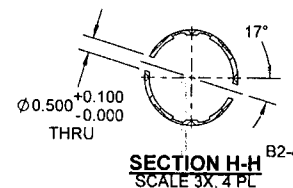
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL







**SECTION G-G**  
SCALE 3X, 4 PL

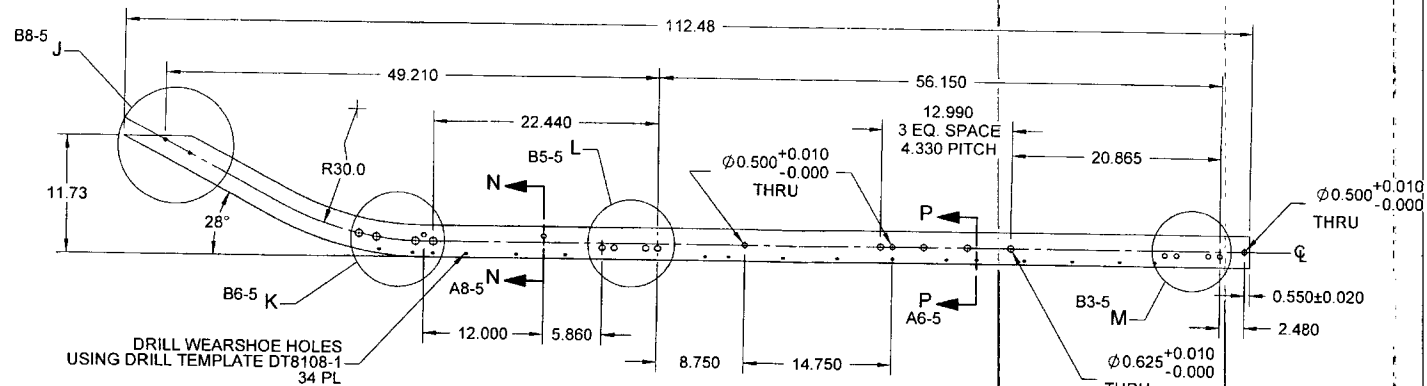


**SECTION H-H**  
SCALE 3X, 4 PL

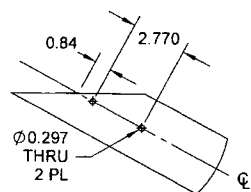
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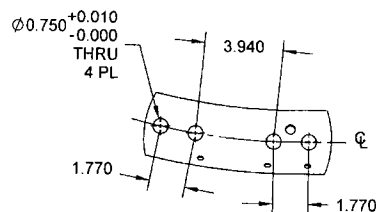
DESIGN	PH	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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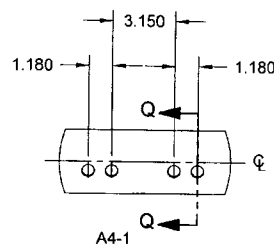
# **D2750-2 RH SKIDTUBE**



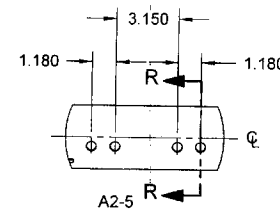
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SCALE 2X



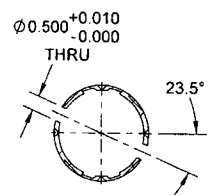
**DETAIL K**  
SCALE 2X



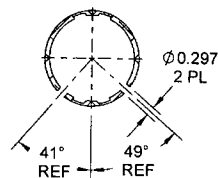
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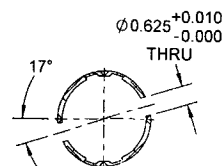
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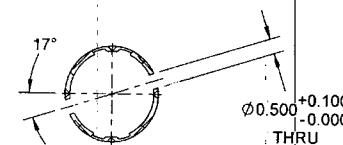
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

*ulu*  
*59993*

**RELEASED**  
08-02-10

DESIGN	PE
DRAWN	PE
CHECKED	PE
MFG. APPR.	PE
APPROVED	PE
DE APPR.	PE
DATE	08.07.16

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F  
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

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8

7

6

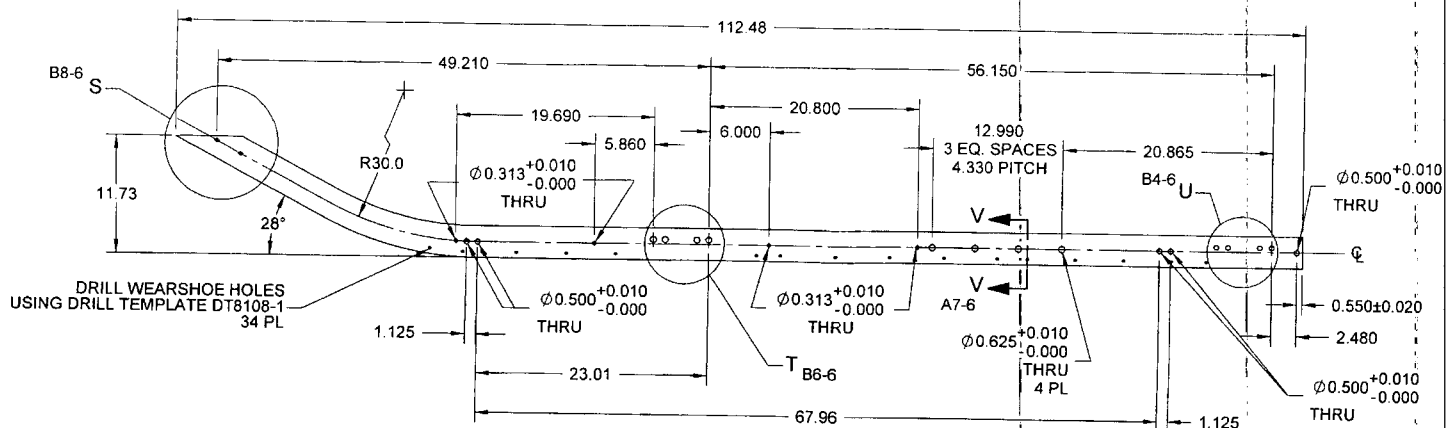
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4

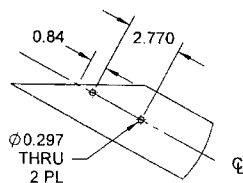
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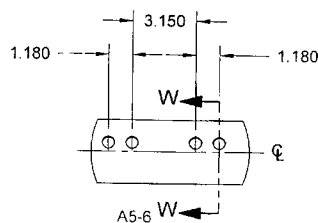
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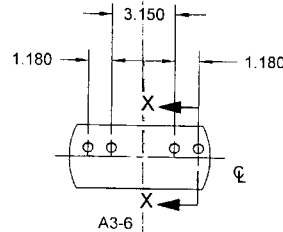
### D2750-3 LH SKIDTUBE



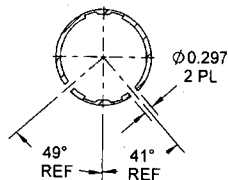
D8-6  
SCALE 2X



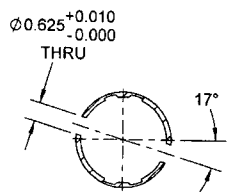
C5-6  
SCALE 2X



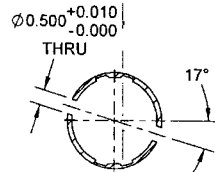
D3-6  
SCALE 2X



C4-6



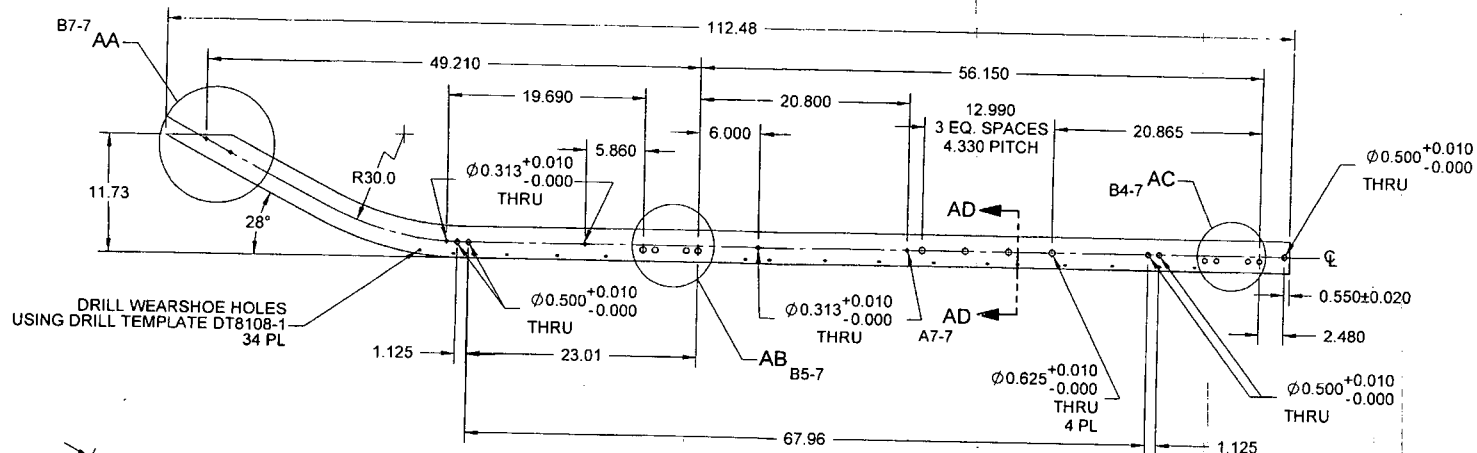
B6-6



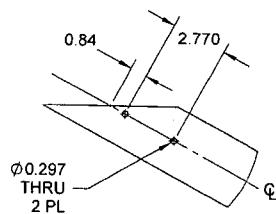
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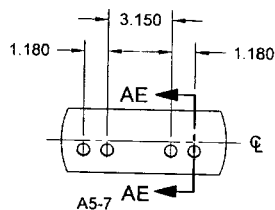
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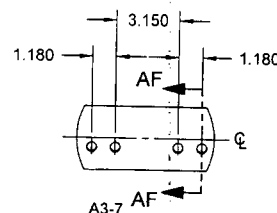
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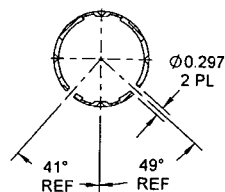
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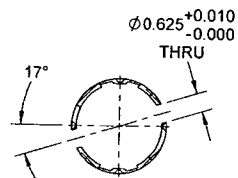
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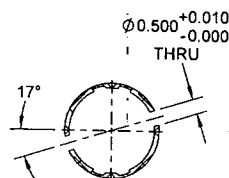
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**SECTION AD-AD**  
SCALE 3X, 17 PL



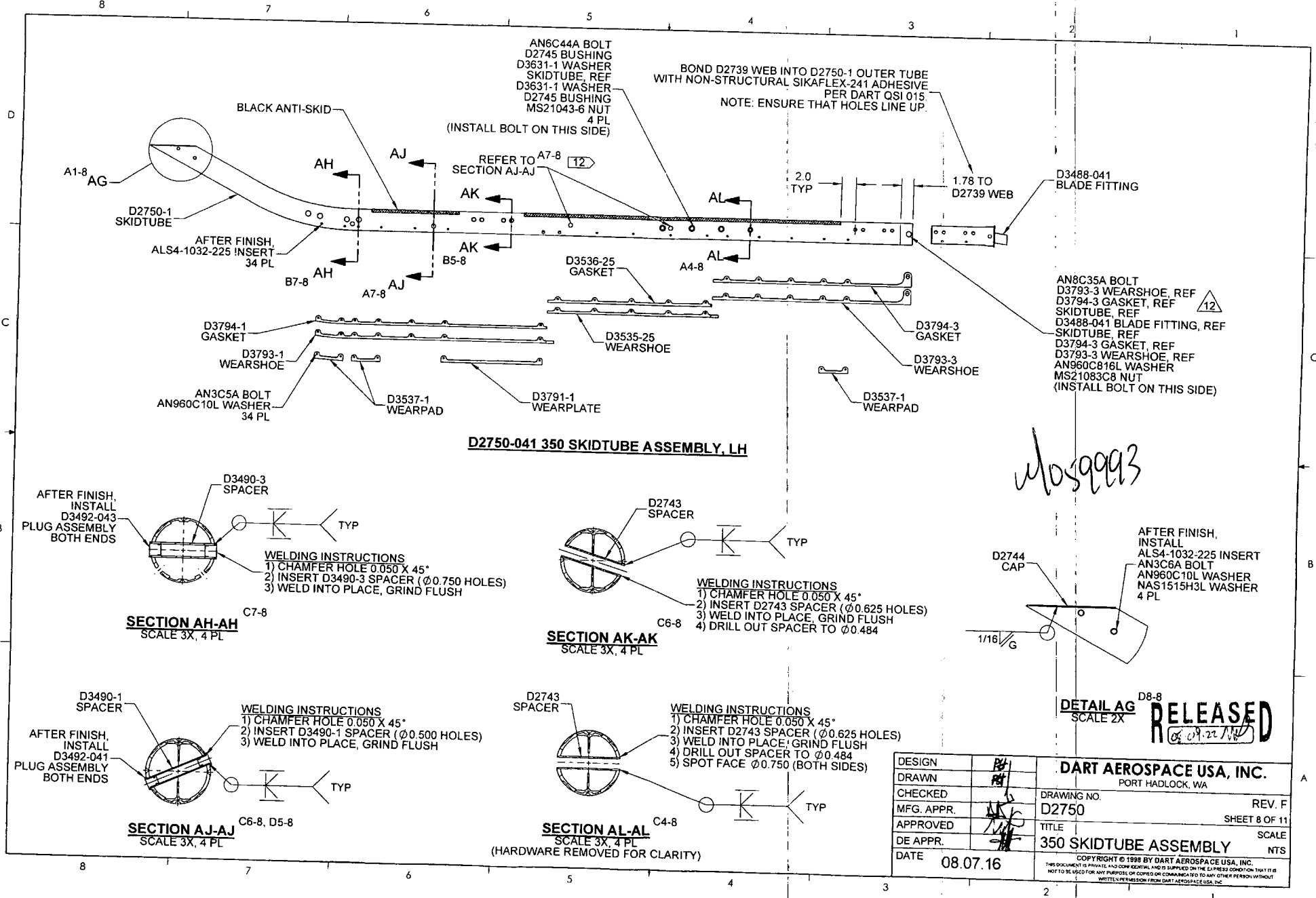
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**SECTION AF-AF**  
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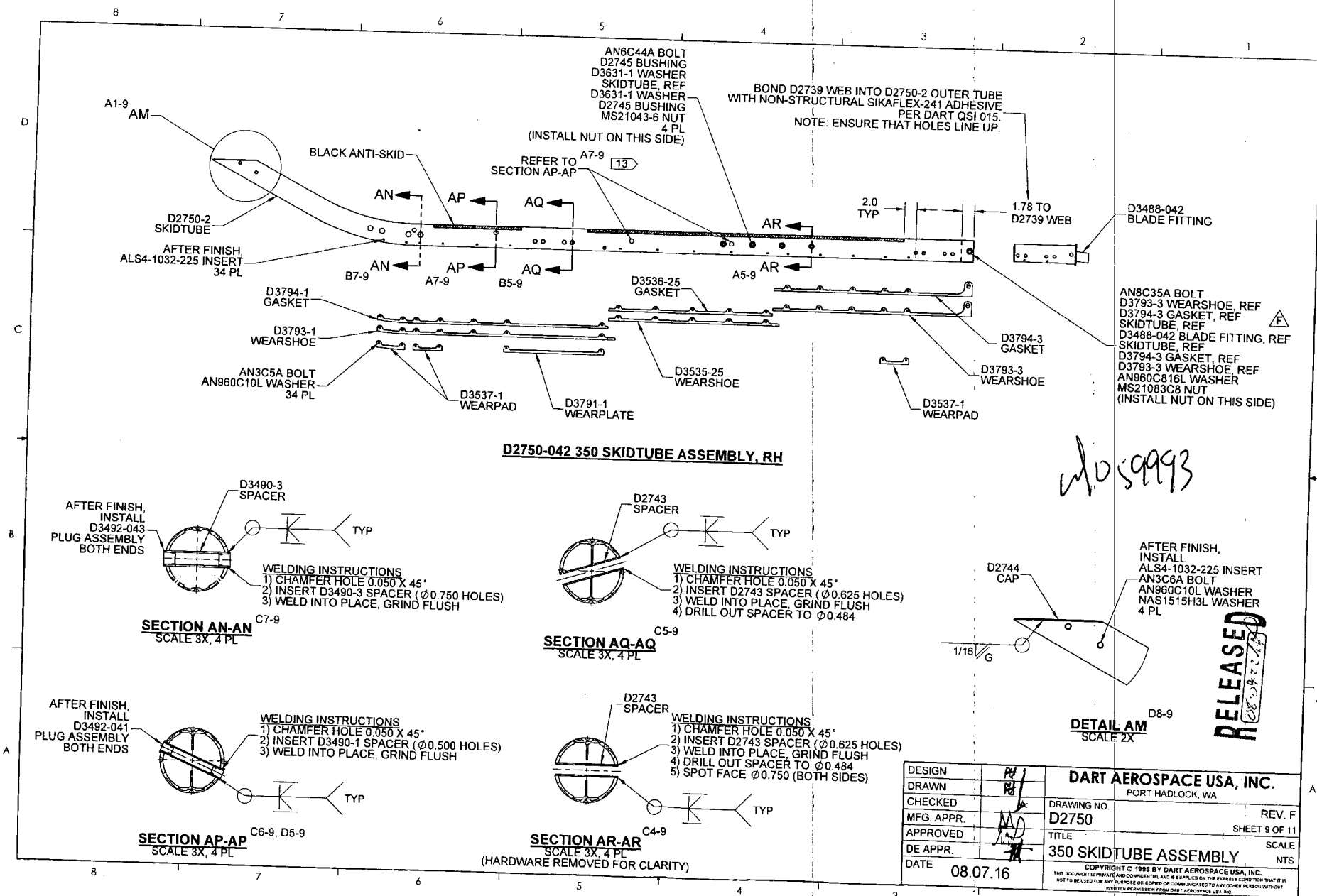
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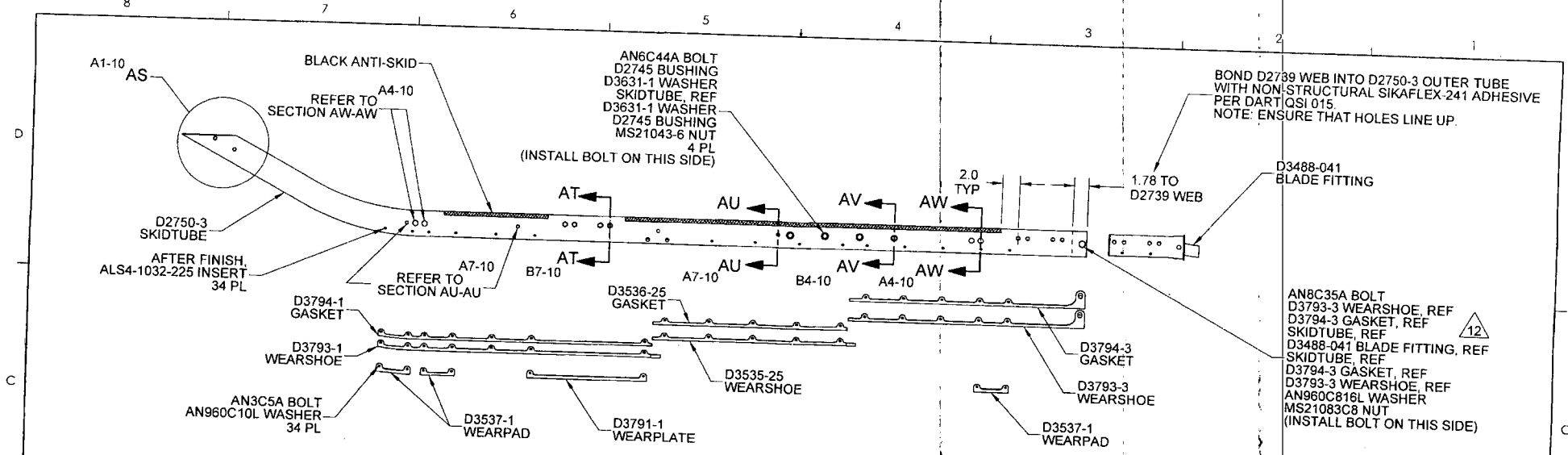
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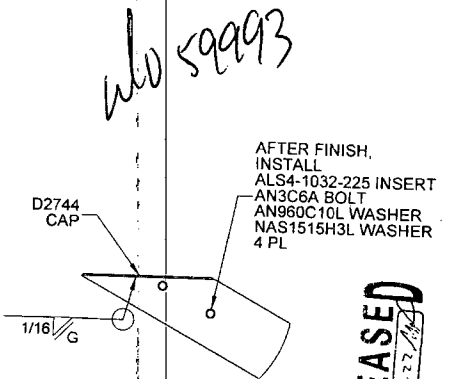
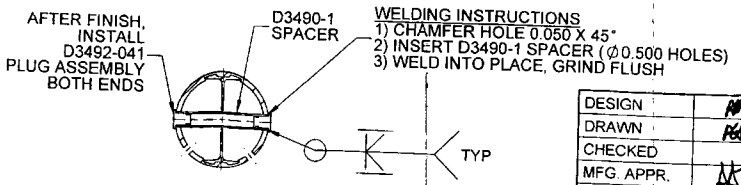
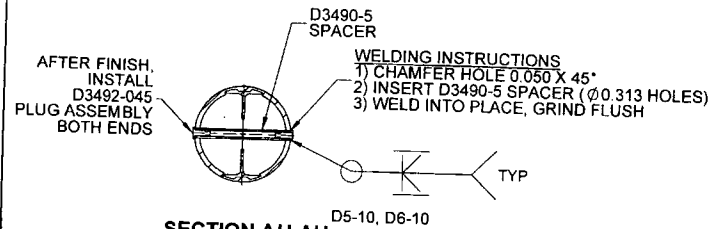
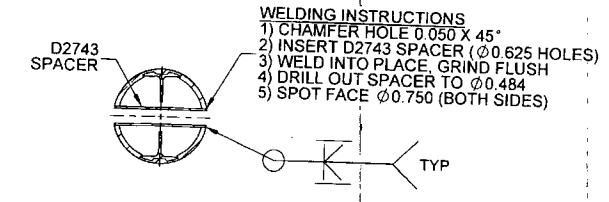
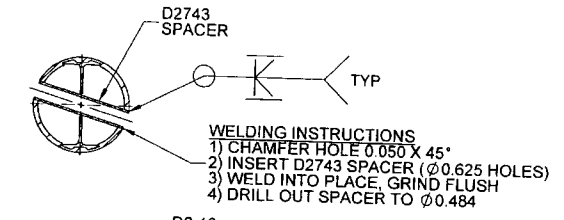
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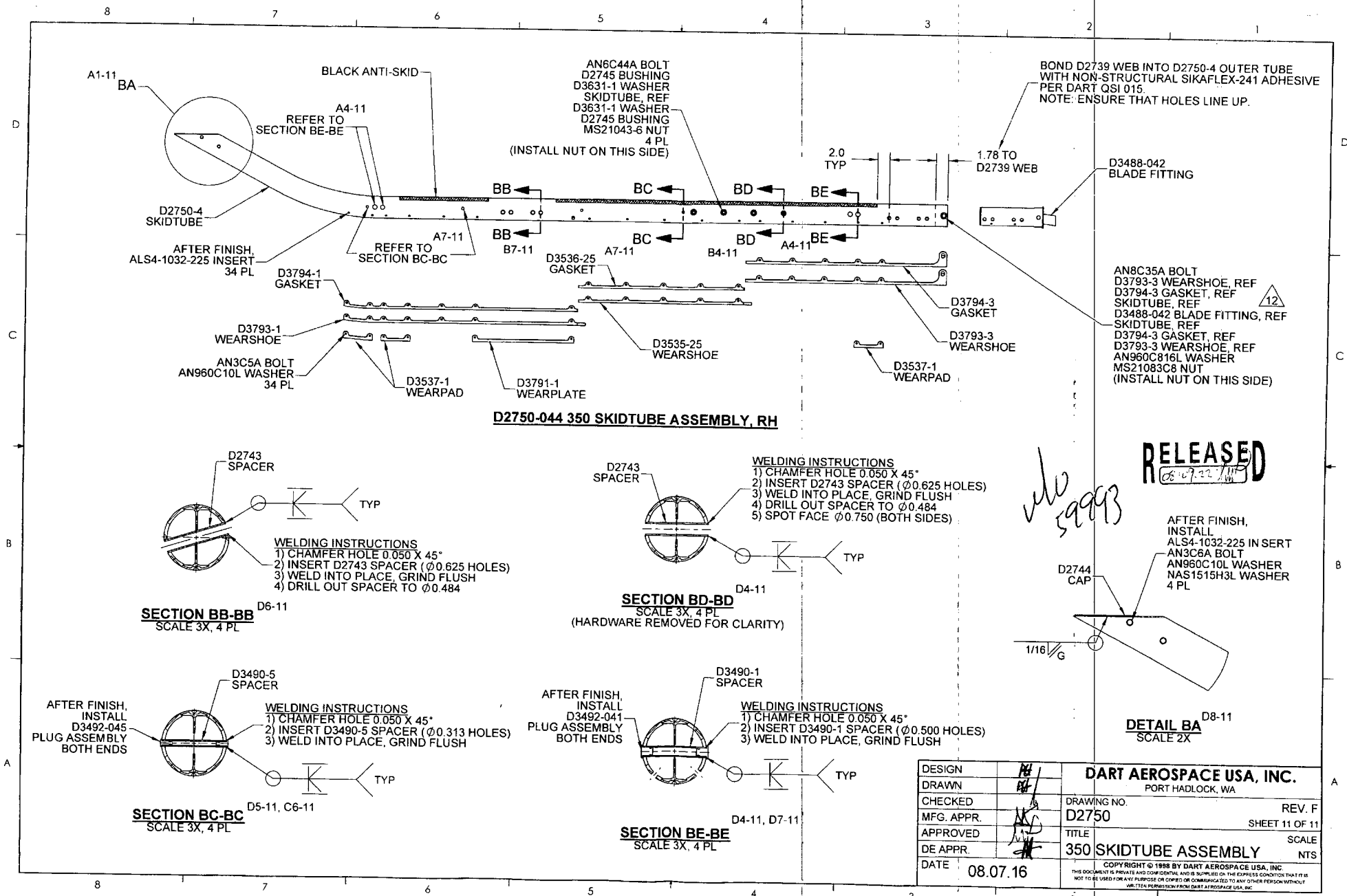
**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



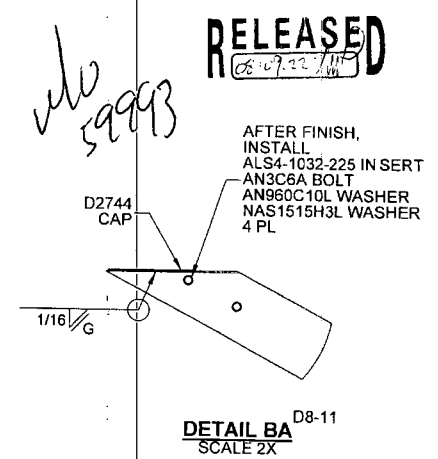
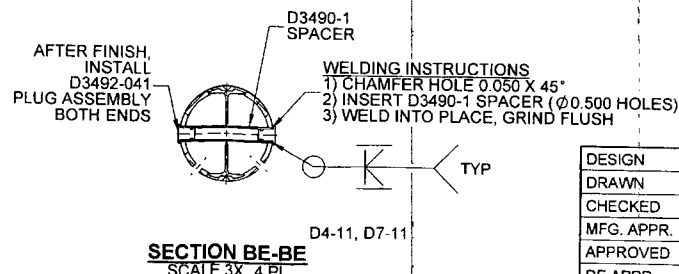
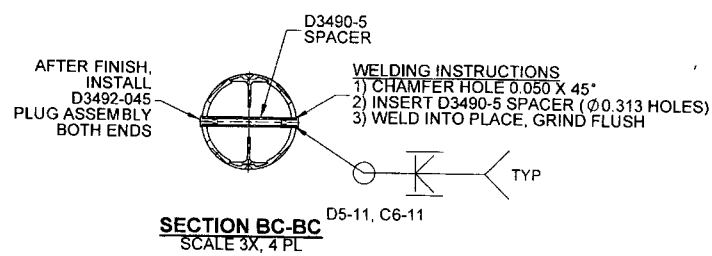
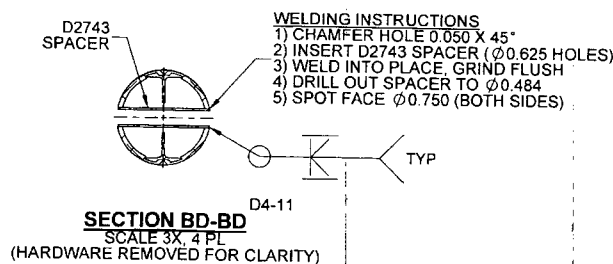
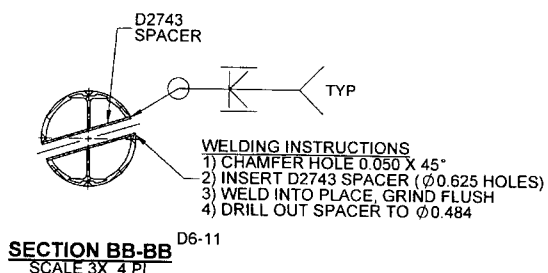
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**RELEASED**





**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



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NO. 234

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 59818  
Part number: D350-626.01  
Description: 320 skid tube  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminium  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Pch. D. A. Date of Test Coupon 10-06-21

Welder Barclay Elliott Date of Test Coupon 10-06-21

The above named individual is qualified in accordance with AWS D17.1.2001 to weld